

# Work Order ID 52617

October 5, 2009 8:08:56 AM

Page 1

Item ID: D3163-3

Revision ID: D

Item Name: Plate

Start Date: 10/05/09 Start Qty: 6.00

Required Date: 10/06/09 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3163

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3163

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B 9-10-5

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-10-5

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27 Sorlus 105

(H)

f

(6)

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Item ID: D3163-3

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Start Date: 10/05/09 Start Qty: 6.00

Required Date: 10/06/09 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1- c'sink holes as per dwg  
2- deburr

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

*Handwritten:* 09/10/05 (5) next page

*Handwritten:* cmd 09/10/06 x5

*Handwritten:* PR 09-10-6 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3163-3 PAR #: \_\_\_\_\_ Fault Category: Prod - Small Prob NCR: Yes No DQA: / Date: 05/10/13  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05/10/13

NCR: <u>52617</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/10/05</u>	<u>130</u>	<u>At the countersink piece moved &amp; hole was damaged</u>  <u>R-C process/human error</u>	<u>/</u> <u>05/10/05</u>	<u>Scrap &amp; Destroy</u> <u>No replace</u>	<u>81</u> <u>09/10/05</u>	<u>S</u> <u>09/10/06</u>	<u>/</u> <u>05/10/05</u>	<u>/</u> <u>09/10/05</u>

NOTE: Date & initial all entries

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Required Date: 10/06/09 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



EP 09/10/06 (5)

09/10/06

PL 09-10-6

# Picklist Print

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Page 1

Work Order ID: 52617

Parent Item: D3163-3RevD

Parent Item Name: Plate

Comments:

Start Date: 10/05/09

Required Date: 10/06/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	61.0033	2.0337			



2024-T3 .063 sheet



189-105

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

61.00332419

102942

1.5

105916

3.69

106223

1.47

109463

0.00947368

110980

5.4854

111787

46.8484505

19059

2

111787

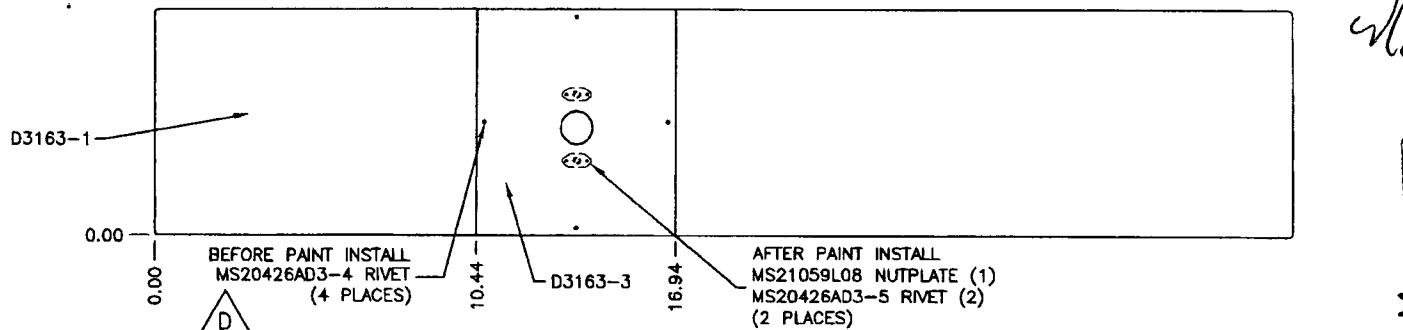


# DART

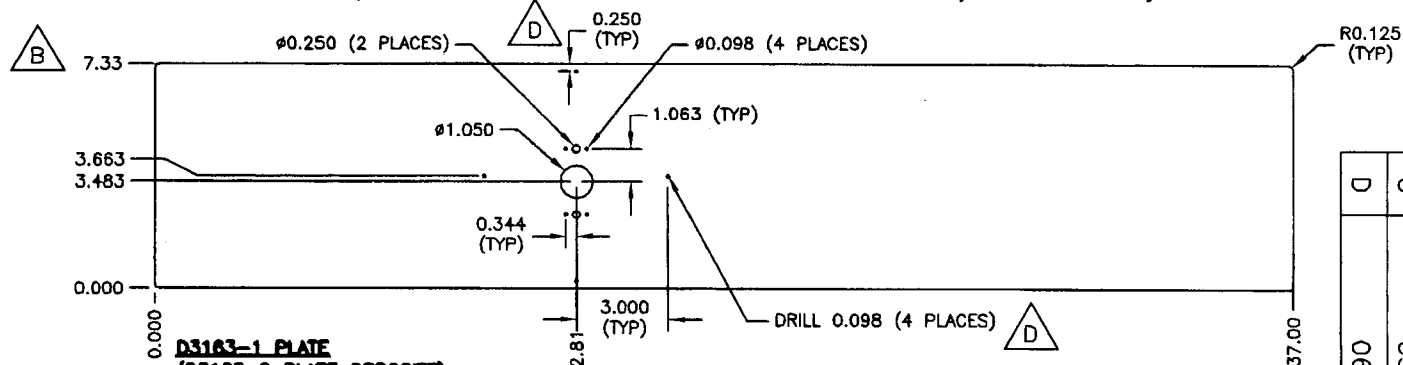
RELEASED  
66-6-29-11

Mo 52617

DESIGN RF		DRAWN BY CB		<b>DART AEROSPACE LTD</b> HAMKESBURY, ONTARIO, CANADA		REV. D
CHECKED	<i>HH</i>	APPROVED	<i>HH</i>	DRAWING NO. D3163	SHEET 1 OF 1	
DATE	06.06.26		TITLE	PLATE		SCALE 1:6
A		02.04.26	NEW ISSUE			
B		04.10.06	7.33 WAS 7:20; REMOVE PERIMETER HOLES			
C		05.11.22	ø1.050 WAS ø1.000			
D		06.06.26	ADD 4 RIVETS; REMOVE ADHESIVE			



D3163-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19  
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)

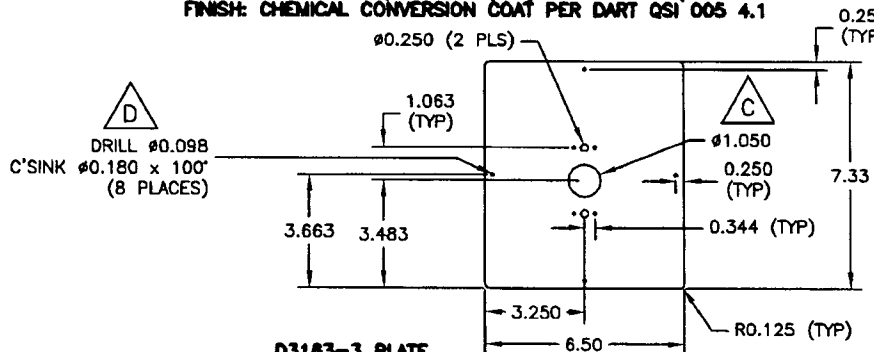


**D3163-1 PLATE**

**(D3183-2 PLATE OPPOSITE)**

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR  
6061-T6 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M6061T6S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 0.250

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



**D3163-3 PLATE**

MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR  
6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

GENERAL NOTES:

- 1) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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